

20-8412



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2583

Job Sheet 211658



Part No: D2583

Job Qty: 20 pcs

Part Name: Latch Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/23/20

Job Tracking No:

Due Date: 8/10/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV B IPP: C 00.11.01 Removed P/O for Powder Coat-in house process DM IPP: D

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		8/7/20	0.17	0.50	Waterjet - Flow		on 20/08/08
120	QC 8	20 pcs		8/7/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

AUG 06 2020

40
9-89

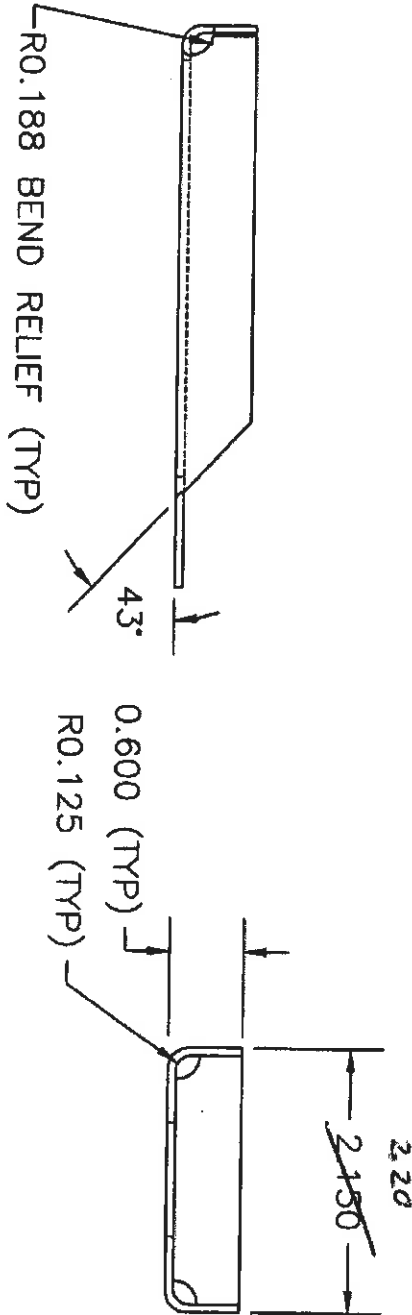
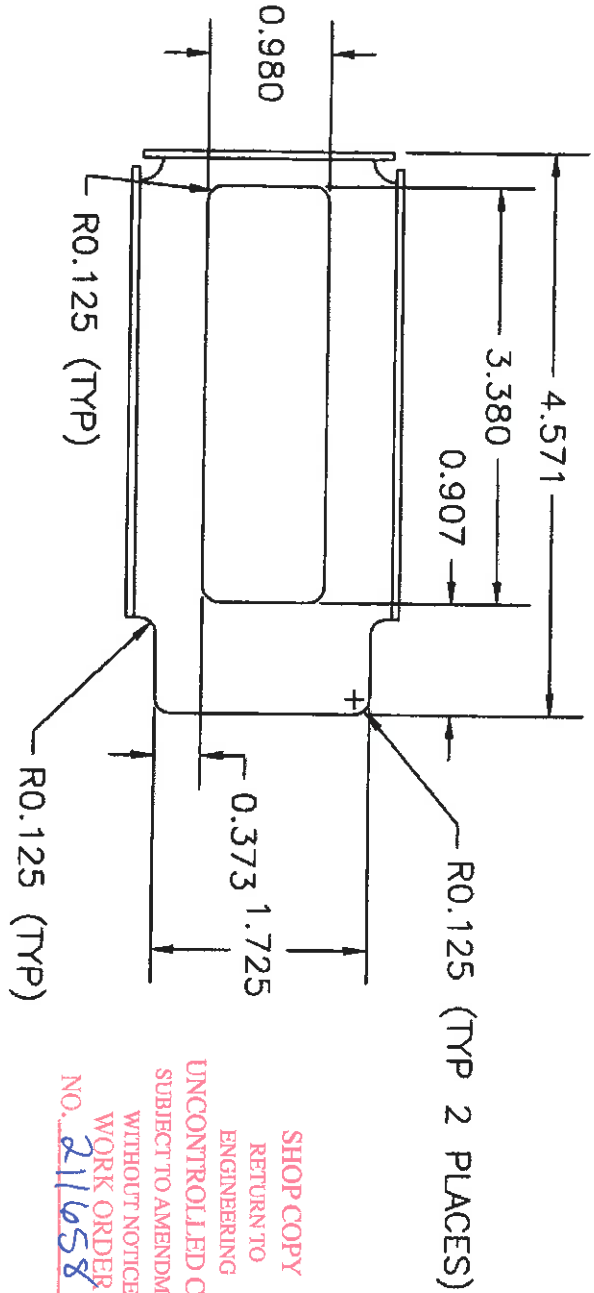
130 Small Fab - 2 - B4B	20 pcs	8/7/20	0.00 0.53	QC 8 - 82	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	AUG 10 2020
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
140 QC 5	20 pcs	8/7/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	DAC 9 20-8-12
				QC 5 - 50	9-80
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
150 Handfinish - 1-1 Chemical-B4B	20 pcs	8/8/20	0.00 20.00	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	2020/08/12
160 Powdercoat - 1 White GI(A)- B4B	20 pcs	8/10/20	0.00 0.53		Powdercoat - 1 - B4B	
M 254/4601 START: 1:10. O.T. 320 FINISH: 1:40.				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B	20.08-12	
				Powdercoat - 4 - B4B		
				Powdercoat - 5 - B4B		
				Powdercoat - 6 - B4B		
				Powdercoat - 7 - B4B		
				Powdercoat - 8 - B4B		
				Powdercoat - 9 - B4B		
				Powdercoat - 10 - B4B		
				170 QC 3	20 pcs	8/10/20
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43	DAS	
				QC 3 - 24	81	
				QC 3 - 61	9-89	
				QC 3 - 81	AUG 12 2020	
				QC 3 - 82		
				QC 3 - 87		
180 Packaging 3-1 - Stock - B4B	20 pcs	8/10/20	0.00 0.00	Packaging 3 - 1 - B4B		
8 pcs M 254/4601				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B	DAS	
				Packaging 3 - 5 - B4B	28	
				Packaging 3 - 6 - B4B	9-89	
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B	AUG 12 2020	
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		

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				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	20 pcs	8/10/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9.59
				QC 21 - SA - 77	
Part Op 100 - 1-Cut as per Dwg D2583 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg)Deburr Form on CNC Brake as per Dwg D2583 140 - (Form as per dwg) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M5052H32S.040	5052-H32 .040 Sheet	2.3380 sf (.1169 ea)	100-Waterjet - Flow - 1	S275576 S153405	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M5052H32S.040	2	65	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Latch Bracket	3.380inches ± 0.010	3.390 3.370		
2	Latch Bracket	0.907inches ± 0.010	0.917 0.897		
3	Latch Bracket	1.725inches ± 0.010	1.735 1.715		
4	Latch Bracket	0.125inches ± 0.010	0.135 0.115		
5	Latch Bracket	0.980inches ± 0.010	0.990 0.970		

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SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21658

KE
99.02.22

RELEASED
KE 99.02.22

DESIGN	MIKE M.	CHECKED	APPROVED	DRAWING NO.	D2583	REV. B	SCALE	2:3
DRAWN BY	RF	KE	99.02.22	TITLE	LATCH BRACKET	DATE	99.02.22	
					NEW ISSUE		96.07.10	
					CHANGE OF FINISH (PER TSR A887)		99.02.22	

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





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CANADA
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www.dartaerospace.com

Container No: S291862



Part: D2583

Job No: 211658

Serial No/Batch: S291862

Revision: 8

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/05/20

DART Engineering Change Request AEROSPACE

Name of Requestor: Valerie Miller Date: AUG 11 2020
 Part Number: D2583 Description: _____
 Change Number/ Rev: B
 Urgency Level: AOG (24 hrs) ☐ Rush (2 weeks) ☒ SIOP/Stock (1 month) ☐
 Required by Date: AUG 11 2020
 Requested From: Supplier ☐ Customer ☐ Manufacturing ☒ Engineering ☐

Department/Workcenter: QC / Small Fab
 Job/Work Order: 211658 Container/Serial Number(Optional): S291862
 Operation Number: 140

Problem: Drawing was amended to have width be 2.20", but it was not taken into consideration that the height dim (.6") would be shortened since no extra material was added to width of flat pattern.

Suggested Corrective Actions(Optional):

Amend Flat pattern to reflect 2.20" width and .6" height

*Attach all drawings, pictures and all supporting data.

*If request is approved, a corrective action number a timeline and responsible Engineer's name will be provided.

*Include part number in email subject.

*Email subject should read: ECR Request P/N XXXX

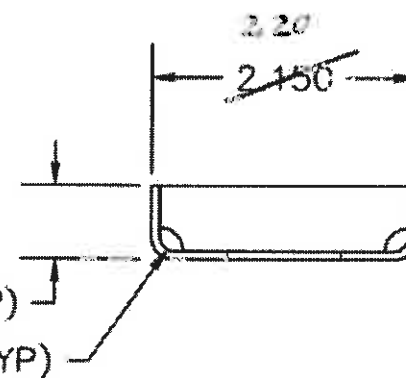
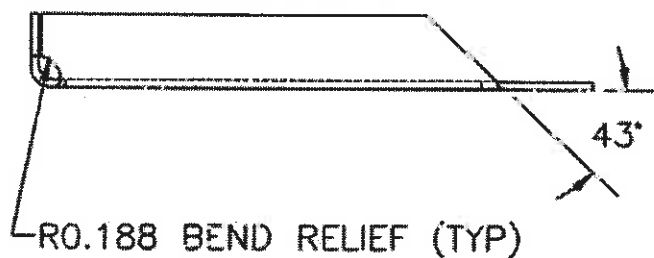
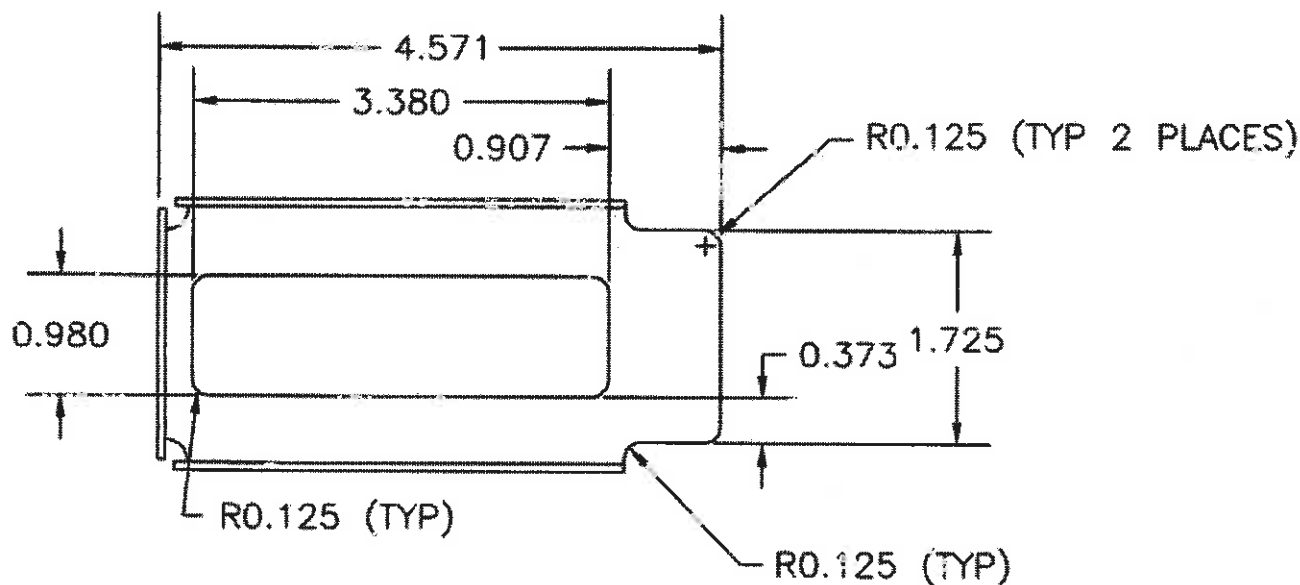
For Engineering Use Only:		ECR#:	_____
Approve ☐	Hold ☐	Reject ☐	Reason: _____
Risk Level	Low ☐	Medium ☐	High ☒
Deviation / CAR	Yes ☐	No ☐	Reference: _____
Reviewed by:	_____	Date:	_____
Responsible Engineer:	1 _____	Estimated Date of Completion:	_____
	2 _____		_____
Program Manager Required:	Yes ☐	No ☐	

DART



RELEASED
K6 002.22

DESIGN	MIKE M.	DRAWN BY	P	DART AEROSPACE LTD
CHECKED	K6	APPROVED	K6	HARRISBURG, ONTARIO, CANADA
DATE	99.02.22	DRAWING NO.	D2583	REV. B
		TITLE	LATCH BRACKET	SHEET 1 OF 1
			NEW ISSUE	SCALE
			CHANGE OF FINISH (PER TSR A887)	2.3



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Entered:

Date:

SEP 01 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8412

Route update only

Job: <u>211658</u>	DISPOSITION		DEPARTMENT/PROCESS			
Part No. <u>D2583</u>	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Water Jet ☐	
	Use-as-is ☒	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
	Quality ☐					
Date: <u>AUG 11 2020</u>	Sequence #: <u>QC-5</u>	QTY Affected: <u>28 of 28 pcs</u>		MRB (QSI042) <u>SM 20/08/14 20-8-14</u>		
Description Work Order Deviation		Disposition		Completed By		
Width dimension is 2.15", should be 2.20" Outside of .03 tol DAS 81 9-89		Scrap and replace - acceptable for 8 pcs. - split work for 8 pcs and quarantine balance for engineering evaluation. (on job 211658.A) Bracket was test fitted and no effect to function was found. PD.		AD 20-8-14 Lead hand / Supervisor DAS 9 9-89 20-8-12 QC / QA Coordinator DAS 9 9-89 20-8-12		
Root Cause		FAULT CATEGORY				
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	☒ Outside Tolerance		
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐		
Handling/Presservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐		
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐		
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐			
Human Factors ☒	Other/Details:					